

Work Order ID 132109

Monday, April 27, 2015 9:57:33 AM

132109

ASAP

Page 1

Item ID: D4049-2 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lug
Start Date: 4/27/2015 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/27/2015 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: MCS Date: 150427 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4049	B

100		0.00				4			
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 2.200" LONG								

110		0.00				4			
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	mill as per dwg and FOLIO FA900								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								

DEBURR

DAS
40
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Misidentified ☐	Past Due ☐								

Work Order ID 132109

Monday, April 27, 2015 9:57:33 AM

132109

Page 3

Item ID: D4049-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 4/27/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/27/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-04-28

MLJ 15-04-28

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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		OTHER : ☐			

Picklist Print

Monday, April 27, 2015 9:57:36 AM

Page 1

Work Order ID: 132109

132109

Parent Item: D4049-2

D4049-2

Parent Item Name: Lug

Start Date: 4/27/2015

Required Date: 4/27/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP Rev:B
as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X1.500		Purchased	No			100	f	24.2490	0.1501	1			

M304B0 500X1 500

304 BAR .500 x 1.50

Location

MAT009

113762

116135

Loc Qty

24.249

13.333

10.916

Loc Code

P150427

7

DQA: _____ Date: _____



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				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

DQA: _____ Date: _____

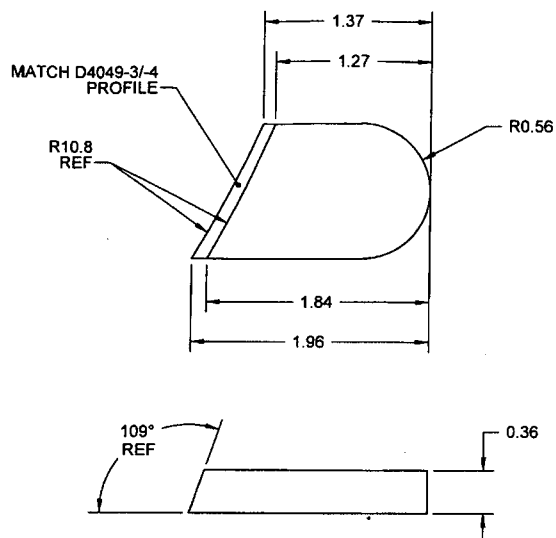
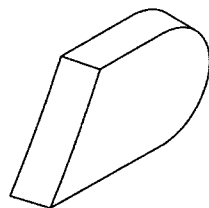


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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								



D4049-1 LUG (SHOWN)
D4049-2 LUG (OPPOSITE)

NOTES:

- 1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4049	REV. B
MFG. APPR.	RF	TITLE	SHEET 4 OF 7
APPROVED	RF	MOUNTING LUG ASSY	SCALE
DE APPR.	RF		NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

STANDARD
COPY
NO. 132109 MW
1504-27

RELEASED
2010-04-14
MR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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